

Date: Tuesday, 23/09/2008 10:22:27 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	42231		
Estimate Number :	11110		
P.O. Number :		Part Number :	D33047
This Issue :	23/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3304 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JUL 08.9.23</u>	Due Date :	20/10/2008
Comment :	Est A 04.09.07 New issue KJ/JLM Est B 08.08.06 waterjet EC verified by DD		

Qty: 12 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0 sf(s)/Unit Total : 1 sf(s)

304/316 .040 Sheet

batch: 109088 1B 8-10-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3304

Dwg Rev: B

Prog Rev: B

1B 8-10-22



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



1B 8-10-22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 08/10/22 (1B)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Deburr

2-Form as per Dwg D3304

3-Tumble N/A

SB 08/10/23 (1B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42231

Part Number: D33047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/23 (H3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/10/24 13

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/24 J

Job Completion



mf 08-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

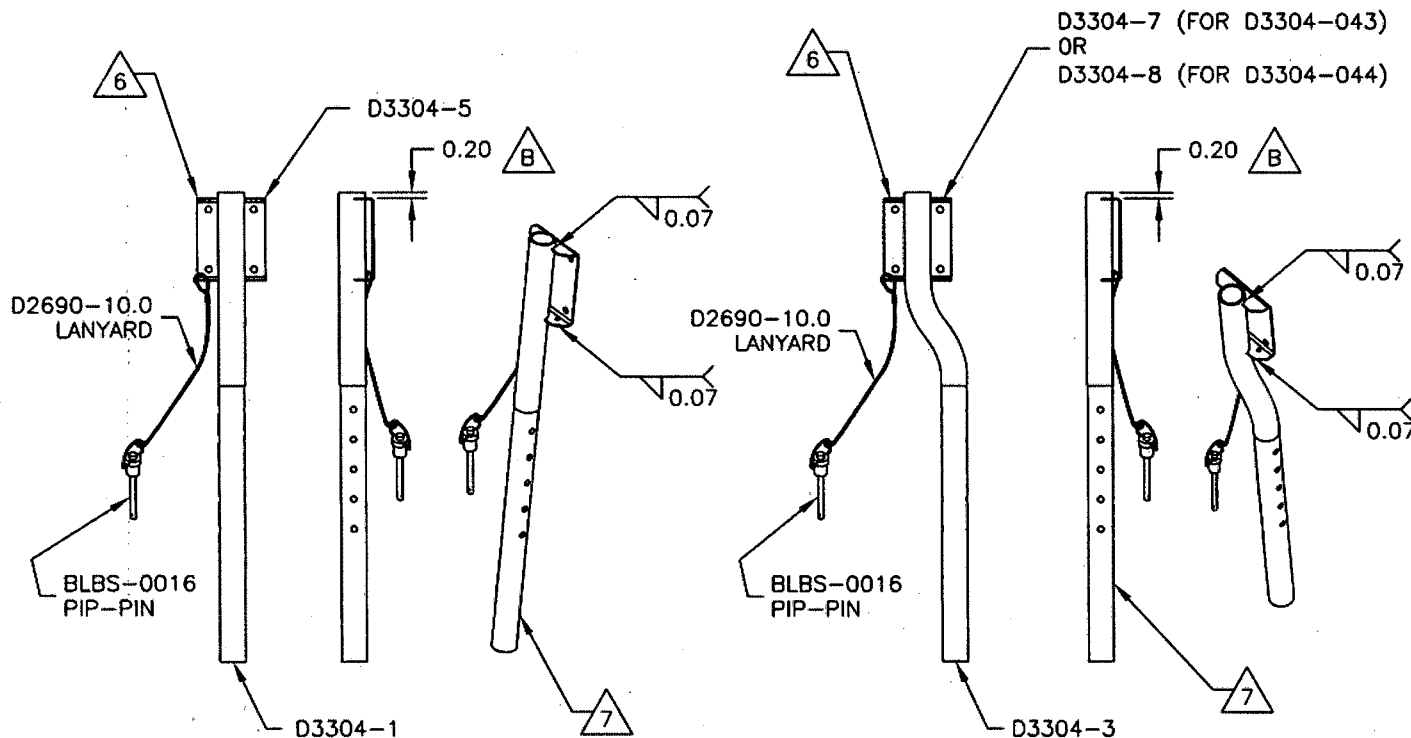
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	RF	HAWESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		D3304
05.07.15		TITLE
		TUBE ASSEMBLY
A	04.08.18	NEW ISSUE
B	05.07.15	UPDATE DIMENSIONS: ADD D3304-7/-8
		REV. B
		SHEET 1 OF 4
		SCALE
		1:6



D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

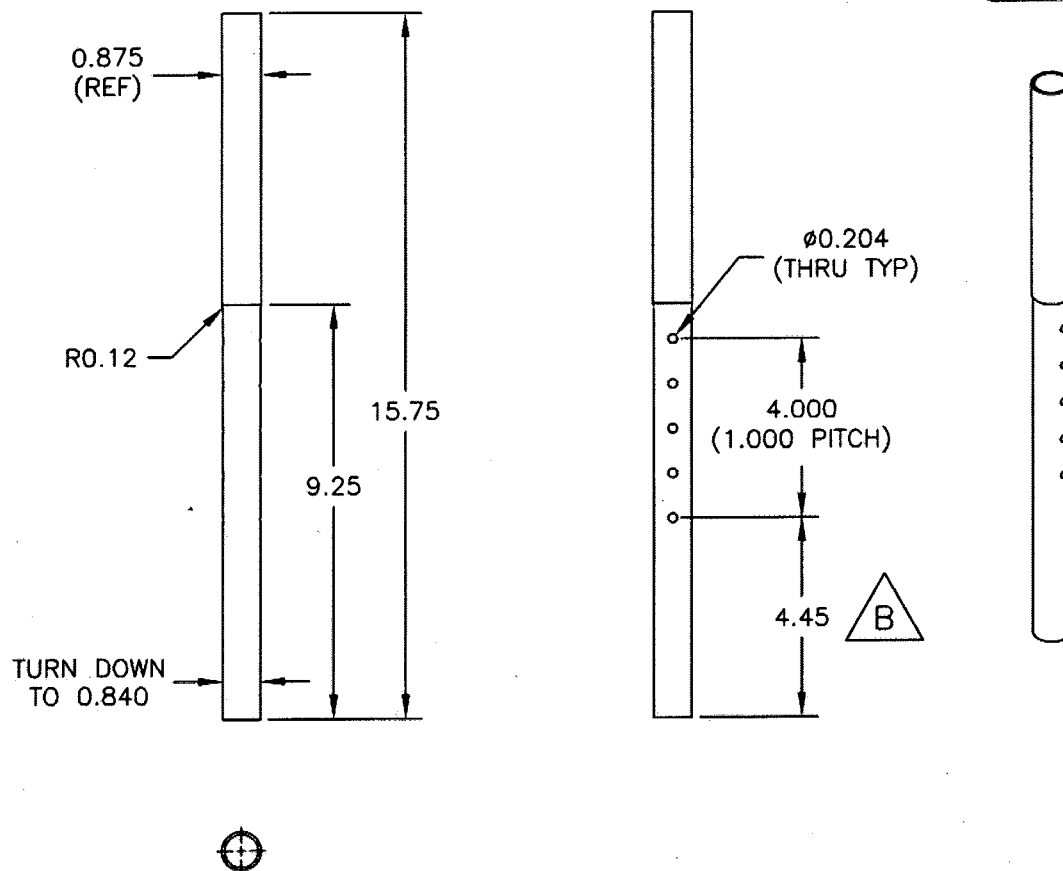
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WORK ORDER
NO. 42003

RELEASED
05.08.11



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DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4

RELEASED
05-08-11



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

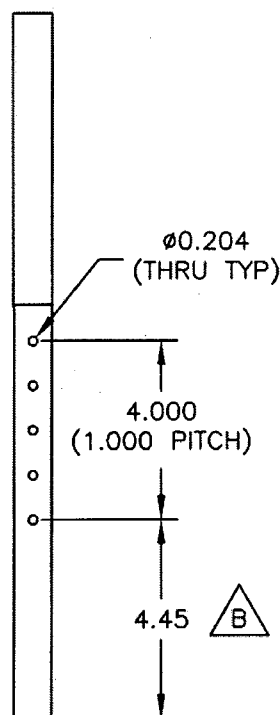
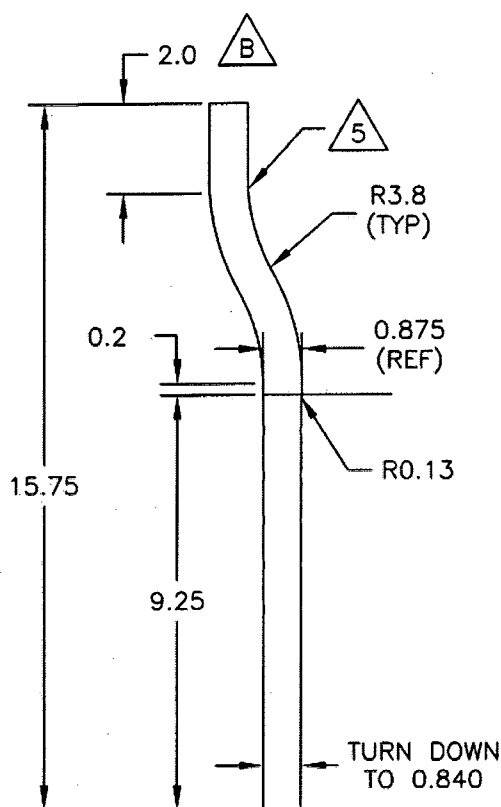
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NO. 42231

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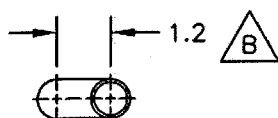
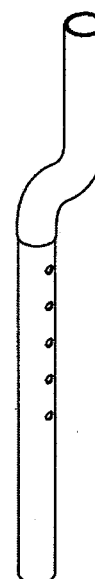
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DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4



RELEASED
05-08-11 *[Signature]*



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

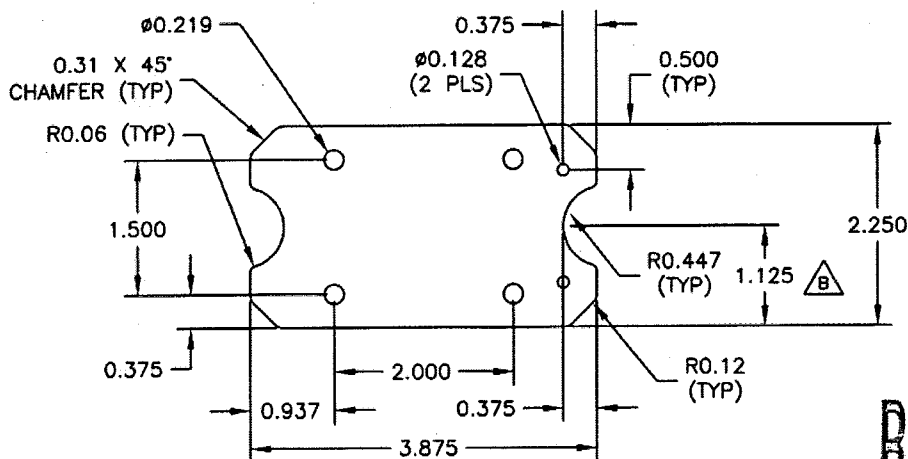
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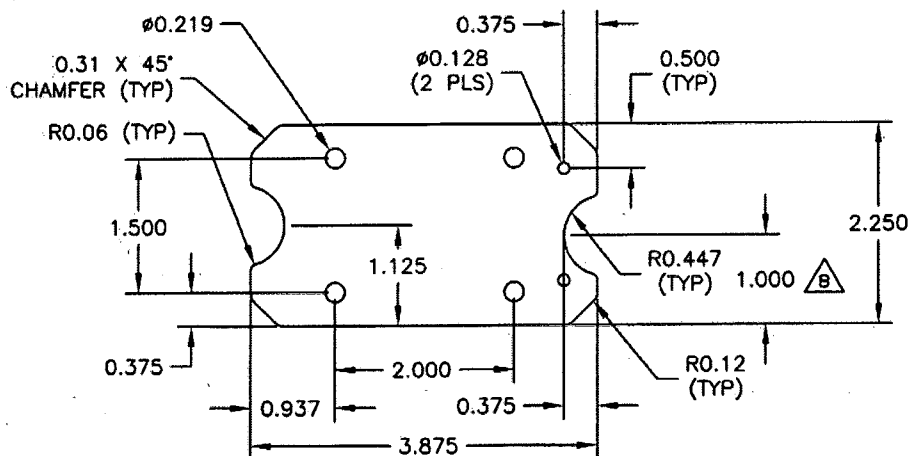


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DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:2

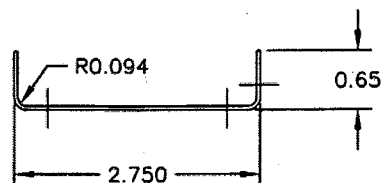


D3304-5 FLAT PATTERN

RELEASED
05.08.11



D3304-7/-8 FLAT PATTERN



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DART AEROSPACE LTD		Work Order:	42231
Description: BRACKET		Part Number:	D3304-7
Inspection Dwg: D3304-7, Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

X

[illegible]

Measured by:	HB
Date:	8-10-27

Audited by:	S
Date:	08/10/22

Prototype Approval:	<i>h</i>
Date:	<i>9</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	